

Work Order ID 63762

Friday, November 12, 2010 11:58:03 AM



CH

Page 1

Item ID: D4278-043 Accept

Revision ID: PRELIM

Item Name: Rib Assembly, Aft Cham

Start Date: 11/15/2010 Start Qty: 200 *mk*

Required Date: 11/16/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *mk* Date: 10-11-12 Tooling:

QC: Date: SPC (Y/N):



Setup Start

Stop



Cust Item ID:

Customer:

PRELIMINARY ISSUE

Run Start

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4278	PA1

100 Weld per dwg A/R S.S. rod Batch: *11585* 0.00

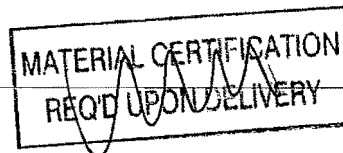
Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg DT

*pl 10.11.16*

110 QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*pl 10.11.16**2*

120 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control



*2**(10.11.17 PA7)*



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Item ID:	D4278-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Rib Assembly, Aft Cham					
Start Date:	11/15/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	11/16/2010	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <i>B/C</i>	0.00							
Packaging	Memo	0.00				<i>2x</i>			<i>10.11.17</i>
Packaging	***STOCK IN BASKET CELL***								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

H. test Rev A1 Rev A2
10.11.22

10-11-17
(2)

POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____

Picklist Print

Page 1

Friday, November 12, 2010 11:58:03 AM

Work Order ID: 63762



Parent Item: D4278-043



Parent Item Name: Rib Assembly, Aft Cham

Start Date: 11/15/2010

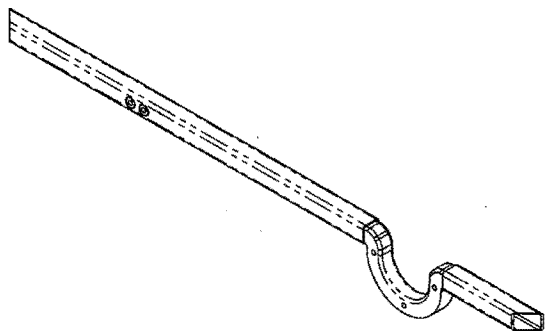
Required Date: 11/16/2010

Start Qty: 1.00

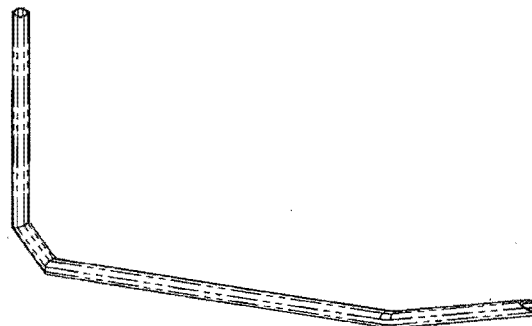
Required Qty: 1.00

Comments: IPP Rev:A 10.11.12 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4277-13 		Manufactured	No			100	Each	0.0000	1	1			
Rib									B63774 → 2				
D4277-15 		Manufactured	No			100	Each	0.0000	1	1			
Rib									B63775 → 2				
D4277-9 		Manufactured	No			100	Each	0.0000	1	1			
Rib									B63773 → 2				



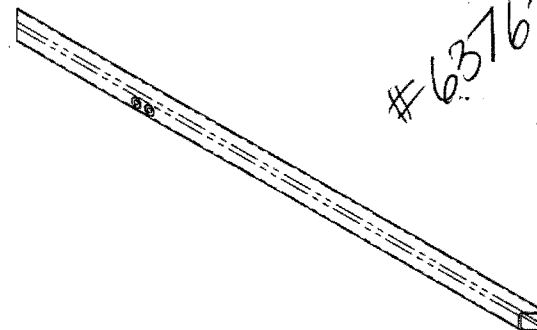
D4278-041 UPPER RIB ASSY-HOOP



D4278-043 RIB ASSY, AFT CHAM



D4278-045 RIB ASSY, FWD CHAM

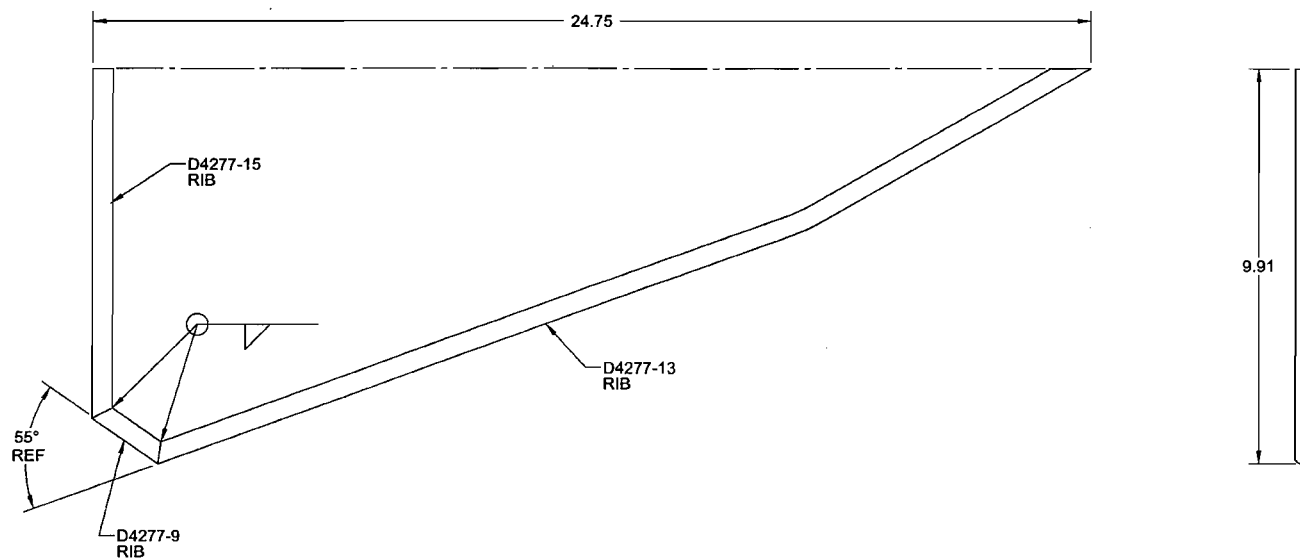


D4278-047 UPPER RIB ASSY-STRAIGHT

PRELIMINARY ISSUE
Nov. 11, 2010

PA1	PRELIMINARY	JPH	10.11.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. PA1
MFG. APPR.	JPH	D4278	SHEET 1 OF 5
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSEMBLY	NTS
DATE	10.11.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM	QTY	PART NUMBER	DESCRIPTION
	043		
		D4278-043	RIB ASSY, AFT CHAM
1	1	D4277-9	AFT CORNER RIB, NOTCH
2	1	D4277-13	AFT DIAG RIB
3	1	D4277-15	RIB, CHAM-VERTICAL



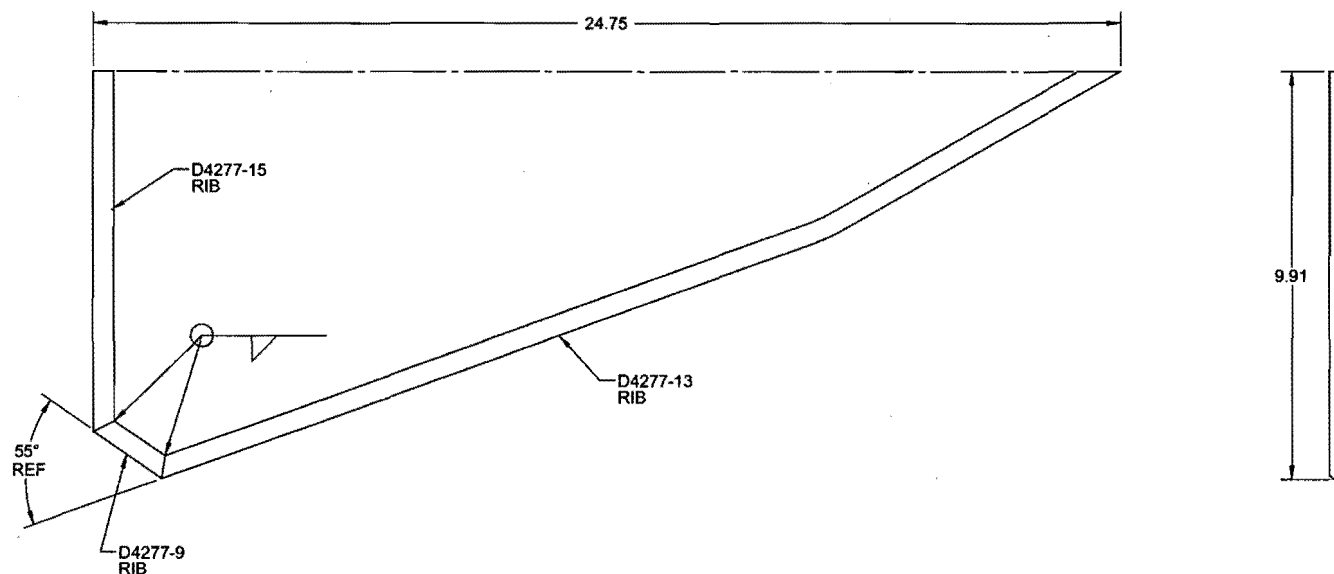
D4278-043 RIB ASSY, AFT CHAM

PRELIMINARY ISSUE
Don H, 2010

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.77 lbs
 - 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4278	REV. PA1
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
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D4278-043 RIB ASSY, AFT CHAM

NOTES:

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DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4278	SHEET 3 OF 5
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